

Work Order ID 82608

82608

Page 1

April-03-12 11:22:35 AM

Item ID: D4593-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cover

Start Date: 4/03/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/03/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D4595

A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 1.500" x 2.500" x 4.120" long

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Machine D4495-3 as per Folio FB093 and Dwg

Dwg Rev: _____

FOLIO REV: _____

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

See attached w/ 80081
n

82608

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/03/12 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 4/03/12 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____

Tooling:

Date:

Stop ***NR2***

QC: _____ Date: _____

SPC (Y/N):

Date:

Insp. Stamp

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0,00

Hand Finishing

150

Fire Red(Ref:4.3.5.10) per Q81005 4.3

0.00

150

Powdercoat

Меро

0.00

Powder Coating

START TIME: _____ OVEN TEMPERATURE: _____
FINISH TIME: _____

Work Order ID 82608***82608***

Page 3

April-03-12 11:22:35 AM

Item ID: D4593-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cover

Start Date: 4/03/12

Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/03/12

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

ML5 12/04/04
W 1204.02

Picklist Print

April-03-12 11:22:35 AM

Page 1

Work Order ID: 82608

Parent Item: D4593-3

Parent Item Name: Cover

Start Date: 4/03/12

Required Date: 4/03/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-02-27 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.500 6061-T6 Bar 1.50 x 2.50		Purchased	No				f	70.9900		0.35			

Location

Loc Qty

Loc Code

MAT004

70.99

103069

12

107387

22.99

16742

36

D4595-3

80681

✓

Work Order ID 80081

80081

Page 1

February-09-12 1:34:36 PM

Item ID: ~~D4595-3~~ D4593-3 9/12.02.16 Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Cover

Start Date: 09/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 23/02/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: M.C.J.

Date: 12/02/09 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4595

A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 1.500" x 2.500" x 4.120" long

SL 12-02-14

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine D4495-3 as per Folio FB093 and Dwg

Dwg Rev: A

FOLIO REV: AA

SL 12-02-15

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 12-02-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80081

February-09-12 1:34:36 PM

80081

Page 2

Item ID: D4595-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Cover
Start Date: 09/02/2012 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 23/02/2012 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				1	1		
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
150 *150* Powdercoat Powder Coating	Fire Red(Ref:4.3.5.10) per QSI005 4.3 Memo	0.00 0.00							

W113645

START TIME: 3:30
FINISH TIME: 4:00
OVEN TEMPERATURE:

1X M-12/02/16

1X M-12/02/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80081

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 09/02/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 23/02/2012 **Req'd Qty:** 1.00 *** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
Qty

Reject Number

Insp. Stamp

160

QC3- Inspect Part Finish

0.00

160

0.00

QC

Memo

Quality Control

170

Identify as per dwg & Stock Location: GA

0.00

170

0.00

Packaging

Memo

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

0.00

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-09-12 1:34:40 PM

Page 1

Work Order ID: 80081

80081

Parent Item: D4595-3

D4595-3

Parent Item Name: Cover

Start Date: 09/02/2012

Required Date: 23/02/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 12-02-09 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1 500X02.50 0		Purchased	No				f	78.6000		0.35			

~~*M6061T6B1 500X02 500*~~

6061-T6 Bar 1.50 x 2.50

**

SL 12-02-14

Location

Loc Qty

Loc Code

MAT004

78.6

103069

12

107387

30.6

16742

36

36

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

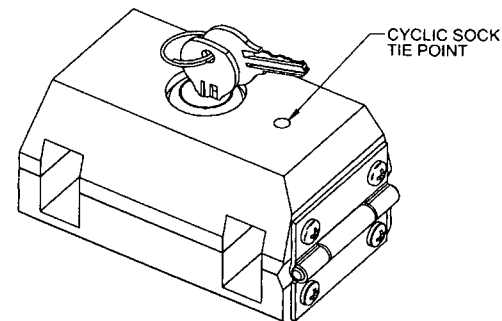
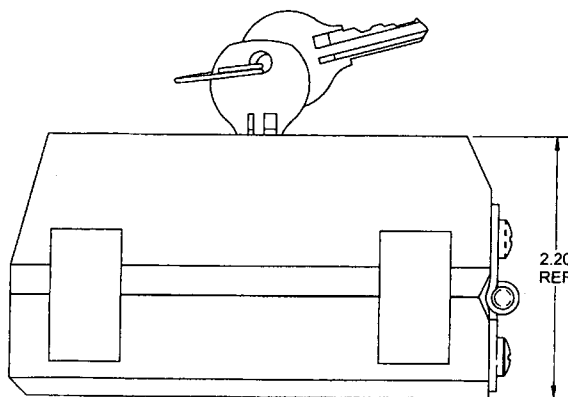
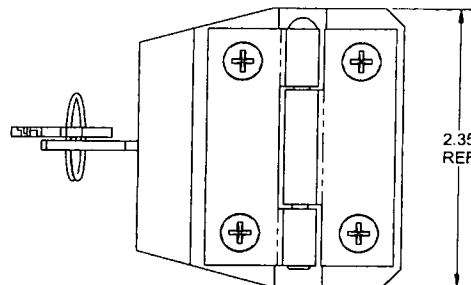
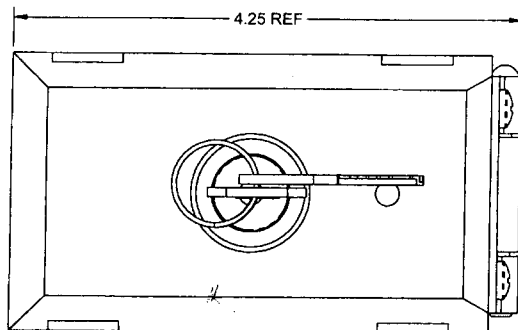
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -051	P/N	DESCRIPTION
	X		D4595-041	TAIL ROTOR DISABLING KIT
	1	X	D4595-051	PEDAL LOCK
	1		D3384-041	CYCLIC SOCK
	1		HX-81	SCREW, SKT-HD
	2		AN960-416	WASHER FLAT
1		1	D3373-5	CAM LOCK ASSEMBLY
2		1	D3385-3	HINGE
3		1	D4595-1	BASE
4		1	D4595-3	COVER
5		5	MS51957-41	PH-HD SCREW, #8
6		2	97395A461	DOWEL PIN (MCMASTER CARR)



80081 M.C.J
12/02/09

RELEASED
12 2012-07-02

D4593-051
D4595-051 PEDAL LOCK

A	NEW ISSUE	RP	12.01.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP	DRAWING NO. D4595	
CHECKED	MP	REV. A	
MFG. APPR.		SHEET 1 OF 3	
APPROVED		TITLE	
DE APPR.	N/A	SCALE	
DATE	12.01.30	PEDAL LOCK ASSEMBLY	
NTS			
COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

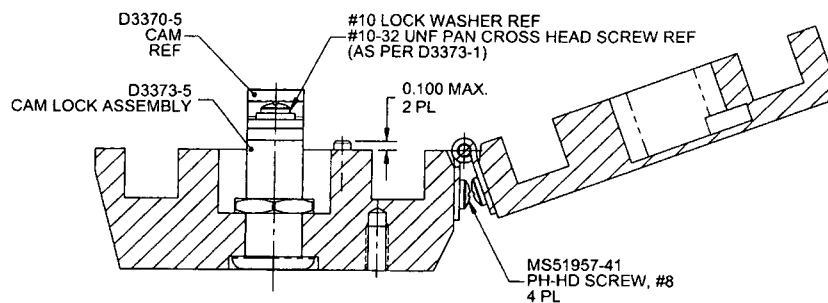
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

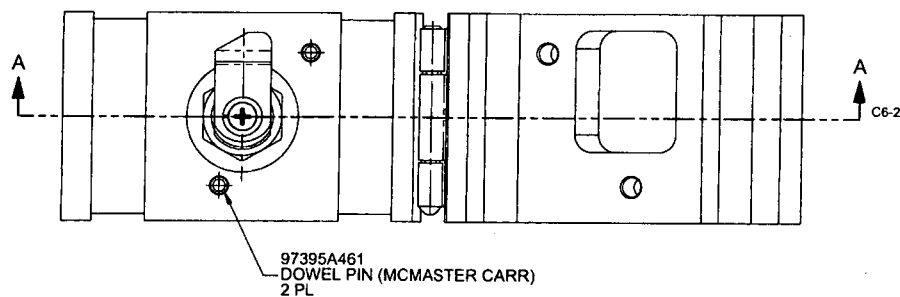
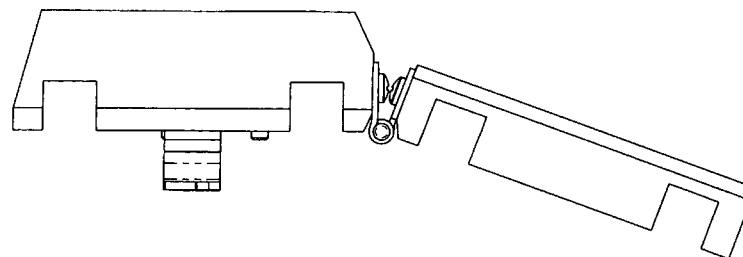
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80081

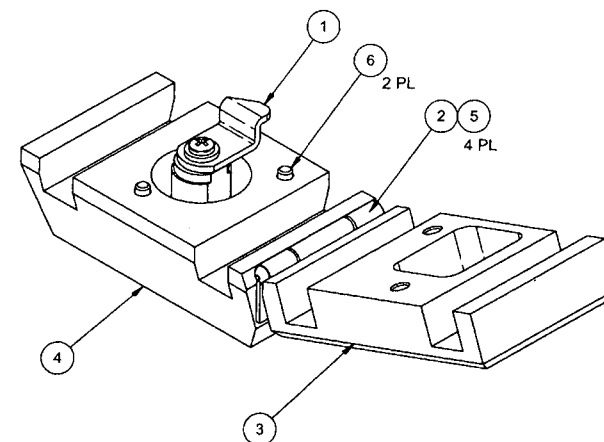


SECTION A-A 84-2



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.75 lbs

D4595-051 PEDAL LOCK ASSEMBLY

RELEASED
2012-02-02

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MP	DRAWING NO.	REV. A
MFG. APPR.		D4595	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	NTS	PEDAL LOCK ASSEMBLY	NTS
DATE	12.01.30	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

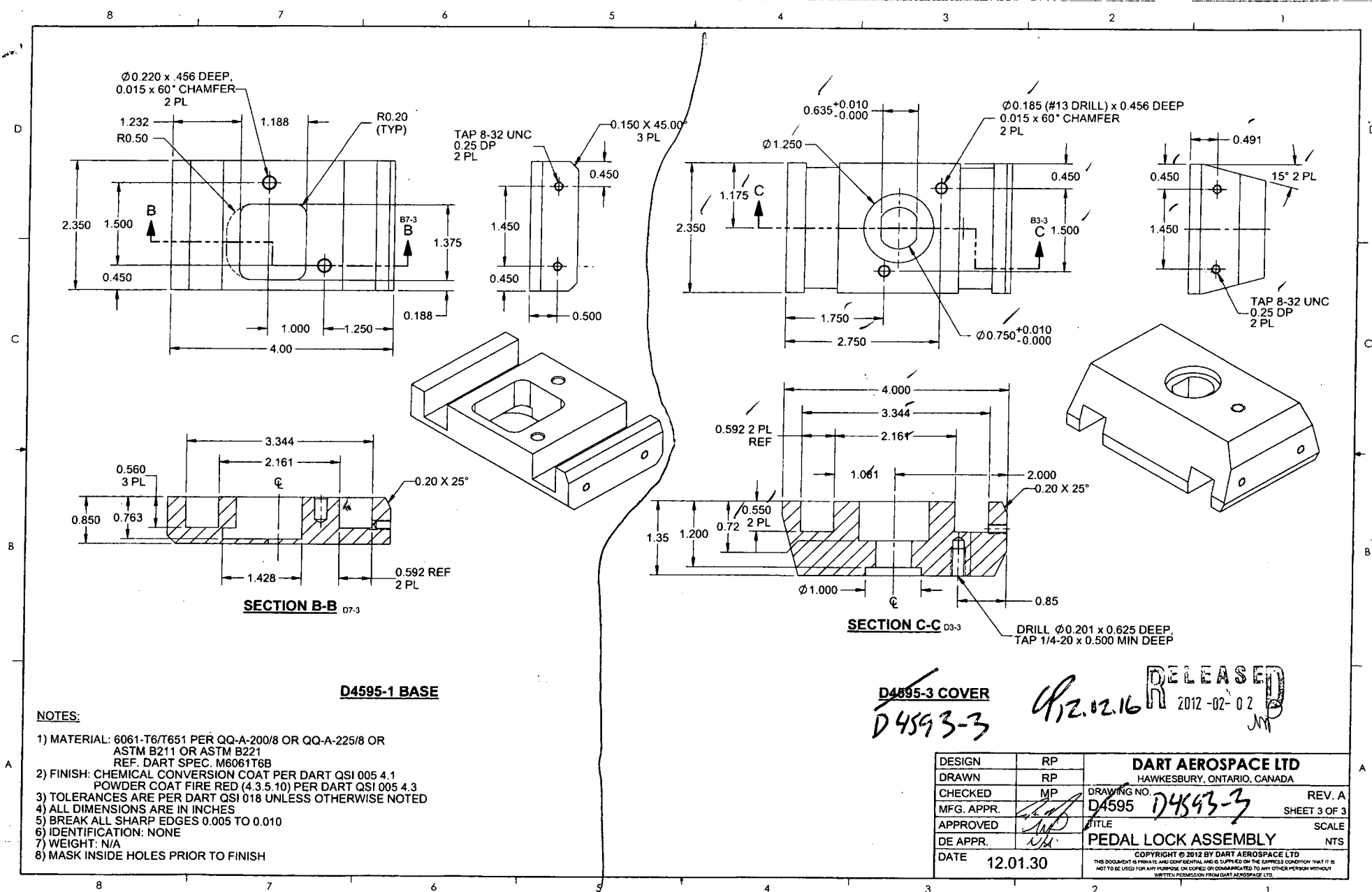
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80081



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 80081
Description: COVER		Part Number: 14595-3
Inspection Dwg: 14595	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.635	+0.010 -0	.640	/		Vern JL-1	
1.250	+0.010	1.251	/			
1.175	+0.010	1.175	/			
2.350	+0.010	2.350	/			
1.750	+0.010	1.750	/			
2.750	+0.010	2.750	/			
.750	+0.010 -0	.753	/			
1.500	+0.010	1.499	/		HG	
.450	+0.010	.451	/		Vern JL-1	
Ø.185	+0.004 -0	.186	/			
.456 deep	+0.010	.450	/			
.491	+0.010	.491	/			
.450	+0.010	.451	/			
1.450	+0.010	1.450	/			
8-32	/	/	/			
15°	+0.5°	15°	/		protractor	
4.000	+0.010	4.000	/		Vern JL-1	
3.344	+0.010	3.344	/			
2.161	+0.010	2.161	/			
1.081	+0.010	1.080	/			
.592	+0.010	.592	/			
.550	+0.010	.549	/			
.72	+0.030	.714	/			

Measured by: JL	Audited by: <i>ork</i>	Preliminary Approval:
Date: 12-02-15	Date: 12/02/16	Date: -

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

